

Date: Wednesday, 7/4/2007 3:42:34 PM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASS'Y
Job Number	: 33300	Part Number	: D35311
Estimate Number	: 12522	Drawing Number	: UNDER REVIEW
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 7/4/2007 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 7/11/2007
Previous Run	: 32207	Qty:	1 Um: Each
Written By	: <i>[Signature]</i> 07-07-12		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:A New Issue 06-09.06 EC		

PROTOTYPE

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.3972 sf(s)/Unit Total: 0.3972 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *M 100742*

IB 07-07-06

CERTIFICATE OF CONFORMITY
REQUIRED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: *PREL*

Prog Rev: *PREL*

2-Deburr if necessary

IB 07-07-06

mf 07-07-09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 07/07/09

5.0	BRAKE NC	NC BRAKE
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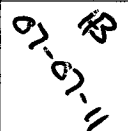
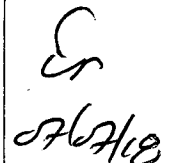
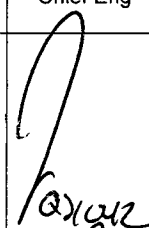
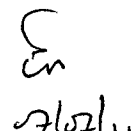
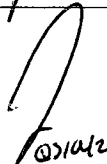
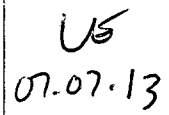
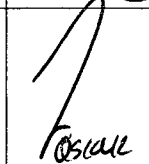

Comment: NC BRAKE

Bend as per Dwg D3531

SB 07/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3531-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 7 Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR: <u>33300</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/11	#20	1 Part SCRAP wrong mat. used (0.050" instead of 0.040") R.C. Human Error		- SCRAP and destroy and replace with correct mat. - Remind employee to be more cautious when pulling mat. - BATCH # <u>M100742</u>	07-07-11 	En 07/07/18 		En 07/07/11 
07.07.13	#6	- BENT SHAPE DEVIATES FROM DWG - 2.32 ± 0.003 IS ACTUALLY 2.28 - PART IS SLIGHTLY TWISTED		- PART IS ACCEPTABLE FOR TEST STRUCTURAL TESTING PURPOSES ONLY	CB 07.07.13	US 07.07.13 		

NOTE: Date & initial all entries

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Drawing Name: BRACKET ASS'Y

Job Number: 33300

Part Number: D35311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

BENT SHAPE OK

INSPECT WORK TO CURRENT STEP

FOR TESTING ONLY

CB

ENGINEERING

APPROVAL

Comment: INSPECT WORK TO CURRENT STEP



07-07-13
07-07-16

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

07-07-19

10.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE



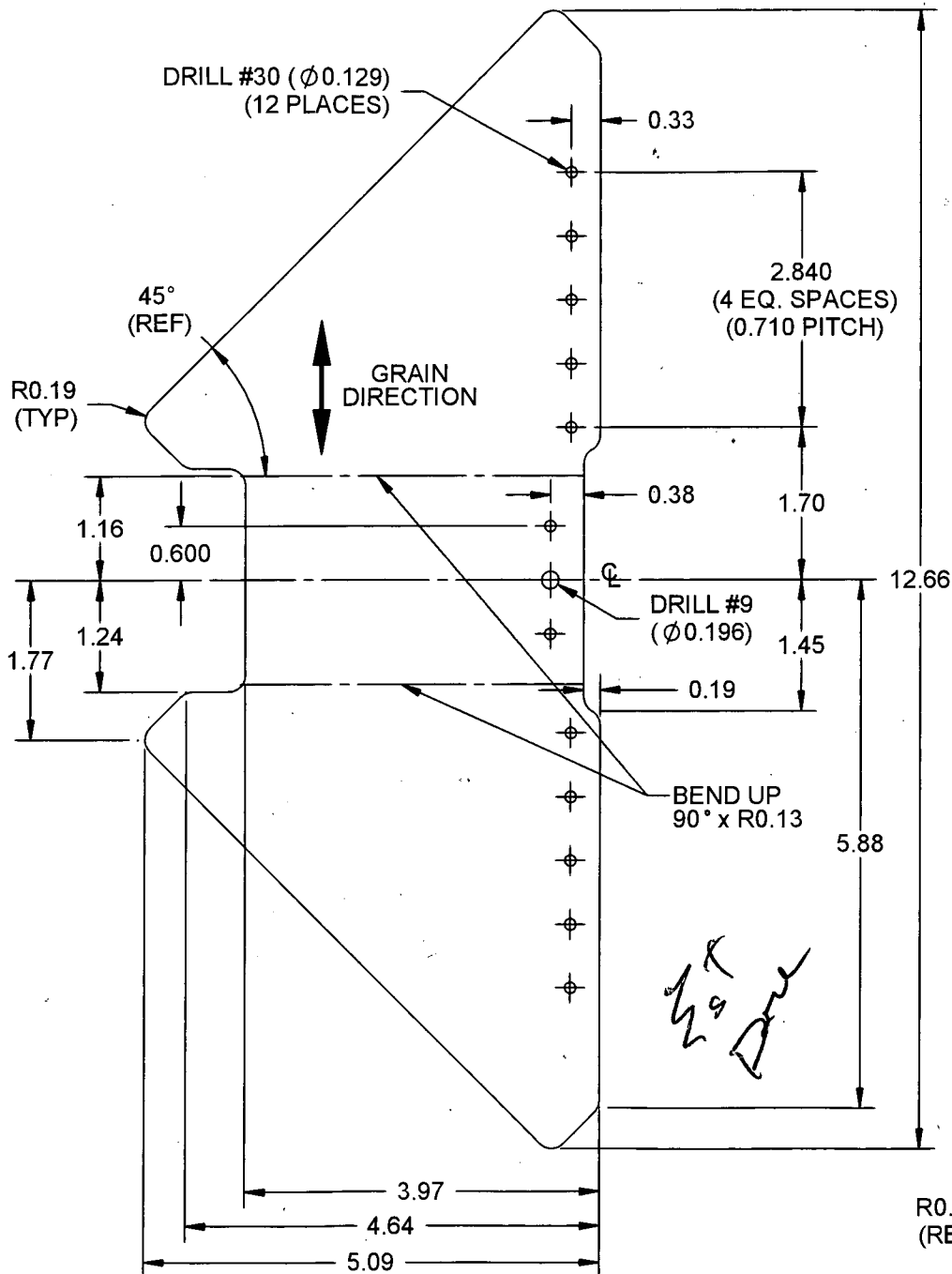
07.07.19

Job Completion

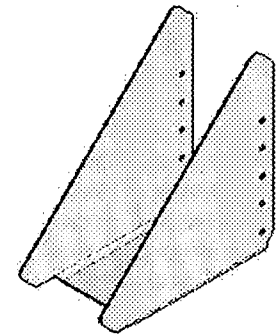


07/07/18

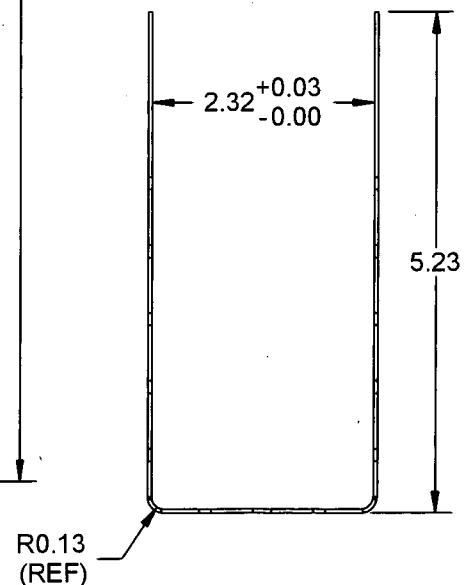
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3531-1F FLAT PATTERN



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
LE 07.06.22



D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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Receiving Report

Date: April 21/06
Supplier: Copper & Brass

Batch No: 1100742
Dart P/O: 1005

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☐
Shipment Complete: Yes ☐ No ☒
Q.C. Inspection ☐

Part No	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M50524325090	Sheet	96	0	0	96	
M6061T6B250X06000		48	0	0	48	
M6061T6B0500X0050		12	10	0	2	

ISR No: _____

Initials of receiver (if shipment OK) [Signature]

Production/Admin: _____
Date: 06/04/25
Received/Costing: RCF1298
Initial: [Signature]

Accounting: _____
Date: _____
AP/MR: _____
Initial: _____


W:\09000\Forms\Purchase\RECREPORT rev B

DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
PLEASE REMIT IN CANADIAN FUNDS		GST/HST		9.66
TOTAL \$				147.73

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH
PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.
G.S.T. REG. NO. 14022393

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

SHIP DATE 04/24/06 SHP		GROSS WEIGHT		QUOTE 30-161074-1	0 OF 10 TEST RESULTS	
ART AEROSPACE		WORK ORDER **		ORDER DATE 04/13/06 ORD		
SHIP TO ART AEROSPACE 270 ABERDEEN ST AWKESBURY ON CANADA K6A 1K7		WORK ORDER 01		DELIVERY DATE 04/24/06 DEL	SHIP BRANCH 30 (04)	SELL BRANCH 30-TOR
				6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y		
				Copper and Brass Sales Canada  A ThyssenKrupp Materials NA company ThyssenKrupp		
NUMBER PO NUMBER 000001005	TERRITORY 01	ENTRY ID 30BXT	CUSTOMER SIGNATURE: _____ DATE: _____			
NAME INDA LACELLE	INSIDE SALES BRIAN TEDESCO		QUANTITY	ORDERED	SHIPPED	
TELEPHONE (613) 632-9577	INSIDE SALES TELEPHONE (905) 696-8100 37622		INVENTORY	54.19 LB	52.00	
SHIP VIA	SHIPPING STATUS		BILLING	2.00 PC	2.00	
TERMINAL	COMPLETE X	PARTIAL	WAREHOUSE			
CUSTOMER COMMON/FRT-CCX	FOB DEST		PACKED WITH OTHER GOODS	UZ3800		
LOADING	FREIGHT STATUS PPD		FINISHED GOODS LOCATION	WARN LABEL:1001		

PART DESCRIPTION 063496-4

061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144
 DART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 dimensions.. Test Results Attn to: QA Department.
 SHEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

SPECIAL INSTRUCTIONS			
Shipping, do not place any packages or goods on top of our material."			
SCRAP	FILLED BY SC	PACKED BY	Q/A AUDIT
RECEIVED HOURS 8-3	MAX SKID WEIGHT 100	LOADING INSTRUCTIONS HAND, CRANE, FORK, DOCK	MAXIMUM BUNDLE WEIGHT 200
BASE	CASES	CUSHP	PKGS
INSPECTION RECORD	SKIDS	BOLTS	TUBES
		CTNS	FLAT
			COILS

TEST RESULTS -----

CERTIFICATE OF COMPLIANCE
 We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
 The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
 Tel: 249-233-5682. We hereby certify that the material above complies with the following specifications:

050711	AMS 4027	ASTM-B209	
		ROHS COMPLIANT	
QUANTITY UOM VENDOR	VEND PO HEAT/LOT	PCS : TAG NO	QUANTITY UOM VENDOR VEND PO HEAT/LOT
52.00 LB CORUS	0CC1837 7124901		